

Work Order ID 137982

Monday, October 19, 2015 8:43:39 AM

137982

To Rev A Drawing 51611/23

~~PRELIMINARY ISSUE~~

Page 1

Item ID: D5331-041

Accept

N900040100

Setup Start

NS1

Revision ID: PRELIM



Item Name: Basket Base Assembly, LH

Stop

NS2

Start Date: 10/19/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/19/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLSDate: OCT 19 2015

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D5331

A4

Rev A 51611/23

100

Weld per dwg A/R S.S. rod Batch: 4131414 0.00***100***

Large Fab

Large Fab

Memo

0.05

Large Fab

1- Assemble ribs and weld as per dwg D5331 using DT10197
inspect before welding mesh

2- Weld gusset and handle plate as per dwg

3- Cut mesh as per dwg D5328-1

4- Tack weld mesh on basket as per dwg D5331 and trim mesh to fit if necessary
and trim to clear fasteners holes on the ends5- Weld hinge (6) and Mounting brackets (2) as per dwg D5331
take lid to locate hinge and bracket

6- Weld D

1xDAS
43
9-89

DEC 15 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 137982

Monday, October 19, 2015 8:43:39 AM

137982

To Rev A S

~~PRELIMINARY ISSUE~~

Page 2

Item ID: D5331-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: PRELIM Stop ***NS2***
Item Name: Basket Base Assembly, LH
Start Date: 10/19/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 10/19/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							DAS 9 9-89
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							DAS 16 9-89 15/12/22 To Rev P13
125 *125* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.01							1 φ 15-12-22 DAS 34 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By																																																									
2417 1 488								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 137982

Monday, October 19, 2015 8:43:39 AM

137982

To Rev A5

PRELIMINARY ISSUE

Item ID: D5331-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: PRELIM Stop ***NS2***
 Item Name: Basket Base Assembly, LH
 Start Date: 10/19/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/19/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130									
Powdercoat	Memo <i>m133714</i>	0.01							
Powder Coating	1- Plug holes and mask only interior of hinge (5) prior to powder coat								
	1ST COAT: <i>2:20</i>								
	START TIME: <i>2:20</i>								
	OVEN TEMPERATURE: <i>400°</i>								
	FINISH TIME: <i>2:00</i>								
	*****2nd coat if necessary*****								
	2ND COAT:								
	START TIME: _____								
	OVEN TEMPERATURE: _____								
	FINISH TIME: _____								
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo <i>29.5 lbs.</i>	0.00							
Quality Control									

1 *φ* *15-12-22* *DAS* *34* *9-89*

1x *φ* *HL 16/01/05* *DAS* *15* *9-89*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 137982

Monday, October 19, 2015 8:43:39 AM

137982

Page 4

Item ID: D5331-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: PRELIM Stop ***NS2***
Item Name: Basket Base Assembly, LH
Start Date: 10/19/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 10/19/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* HandFinish Hand Finishing	Assemble as per dwg Memo	0.00 0.01				1x	1	1610105	
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							DAS 16 9-89 1610105
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>W/O</u> Memo	0.00 0.00				1x	1	1610106	D5337.011 / B137982

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 137982

Monday, October 19, 2015 8:43:39 AM

137982*2w AS*
PRELIMINARY ISSUE

Page 5

Item ID: D5331-041 Accept ***N9000040100*** Setup Start ***NS1***
Revision ID: PRELIM Stop ***NS2***
Item Name: Basket Base Assembly, LH
Start Date: 10/19/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 10/19/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

POSITIVE RECALL
EFFECTIVE OCT 19 2015 AUTH MLC
RELEASED 16 DATE 2016/01/23
9-89

*16-1-15**RD15-1016-01**To Rev A Drawing*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
RECALL EFFECTIVE DATE 03/24/2014				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Monday, October 19, 2015 8:43:43 AM

Page 1

Work Order ID: 137982

137982

Parent Item: D5331-041

D5331-041

Parent Item Name: Basket Base Assembly, LH

Start Date: 10/19/2015

Required Date: 10/19/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 15.10.15 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581		Manufactured	No				Each	52.0000		2			
D2581									**	B134324 → 2x		DAS 43 9-89	NOV 27 2015
Mounting Bracket													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA004	52	
132771	38	
136270	14	

D3913-15		Manufactured	No				Each	4.0000		1			
D3913-15									**	B138459 → 1x		DAS 43 9-89	NOV 27 2015
Wide Handle Plate													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA004	4	
131861	1	
133957	3	

D4016-1		Manufactured	No				Each	0.0000		6			
D4016-1									**	B138081 → 6x		DAS 43 9-89	NOV 27 2015
Hinge Half, Base													

D4021-1		Manufactured	No				Each	3.0000		1			
D4021-1									**	B138943 → 1x		DAS 43 9-89	NOV 27 2015
Handle Plate													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA004	3	
120273	1	
135454	2	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Monday, October 19, 2015 8:43:43 AM

Page 2

Work Order ID: 137982

137982

Parent Item: D5331-041

D5331-041

Parent Item Name: Basket Base Assembly, LH

Start Date: 10/19/2015

Required Date: 10/19/2015

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

sf

561.0000

33.68421

DAS

M304FX0 75-16F

Expanded Metal Flat SS

**** 4 133466 → 33x 43 9-89 NOV 27 2015**

Location

Loc Qty

Loc Code

WA004

561

M132745

63

M132864

18

M132967

160

M133198

320

D5328-3

Manufactured

No

Each

0.0000

1

DAS

D5328-3

Mesh Base, Aft

**** B138092 → 1x 43 9-89 NOV 27 2015**

D5328-5

Manufactured

No

Each

0.0000

1

DAS

D5328-5

Mesh Base, Fwd

**** B138093 → 1x 43 9-89 NOV 27 2015**

D5330-1

Manufactured

No

Each

0.0000

2

DAS

D5330-1

Handle Plate

**** B138120 → 2x 43 9-89 NOV 27 2015**

D3916-5

Manufactured

No

Each

0.0000

2

DAS

D3916-5

Light Rib

**** B139195 → 1x 43 9-89 NOV 27 2015**

D5325-041

Manufactured

No

Each

0.0000

1

DAS

D5325-041

Rib Assembly

**** B138094 → 1x 43 9-89 NOV 27 2015**

D5325-043

Manufactured

No

Each

0.0000

4

DAS

D5325-043

Rib Assembly

**** B138095 → 4x 43 9-89 NOV 25 2015**

D5325-3

Manufactured

No

Each

0.0000

1

DAS

D5325-3

Light Rib

**** B138096 → 1x 43 9-89 NOV 27 2015**

Monday, October 19, 2015 8:43:43 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. 240		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : 2019-07-24		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Monday, October 19, 2015 8:43:43 AM

Page 3

Work Order ID: 137982

137982

Parent Item: D5331-041

D5331-041

Parent Item Name: Basket Base Assembly, LH

Start Date: 10/19/2015

Required Date: 10/19/2015

Start Qty: 1.00

Required Qty: 1.00

D5326-041	Manufactured	No	Each	0.0000	1	DAS 43 9-89	NOV 27 2015
D5326-041							
Rib Assembly							
D5326-043	Manufactured	No	Each	0.0000	1	DAS 43 9-89	NOV 27 2015
D5326-043							
Rib Assembly							
D5327-1	Manufactured	No	Each	0.0000	1	DAS 43 9-89	NOV 27 2015
D5327-1							
Rib							
D5327-3	Manufactured	No	Each	0.0000	1	DAS 43 9-89	NOV 27 2015
D5327-3							
Rib							
D5327-5	Manufactured	No	Each	0.0000	1	DAS 43 9-89	NOV 27 2015
D5327-5							
Rib							
D5327-7	Manufactured	No	Each	0.0000	1	DAS 43 9-89	NOV 27 2015
D5327-7							
Rib							
D5327-9	Manufactured	No	Each	0.0000	2	DAS 43 9-89	NOV 27 2015
D5327-9							
Rib							
D5327-11	Manufactured	No	Each	0.0000	4	DAS 43 9-89	NOV 27 2015
D5327-11							
Rib							
D5327-13	Manufactured	No	Each	0.0000	1	DAS 43 9-89	NOV 27 2015
D5327-13							
Rib							

Monday, October 19, 2015 8:43:43 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Monday, October 19, 2015 8:43:43 AM

Page 4

Work Order ID: 137982

137982

Parent Item: D5331-041

D5331-041

Parent Item Name: Basket Base Assembly, LH

Start Date: 10/19/2015

Required Date: 10/19/2015

Start Qty: 1.00

Required Qty: 1.00

D5327-15

Manufactured No

Each 0.0000

1

D5327-15

**** B138106 → 1x ^{DAS} 43 NOV 27 2015**

Cap

D5329-1

Manufactured No

Each 0.0000

2

D5329-1

**** B138107 → 2x ^{DAS} 43 NOV 27 2015**

Gusset

DQA: _____ Date: _____



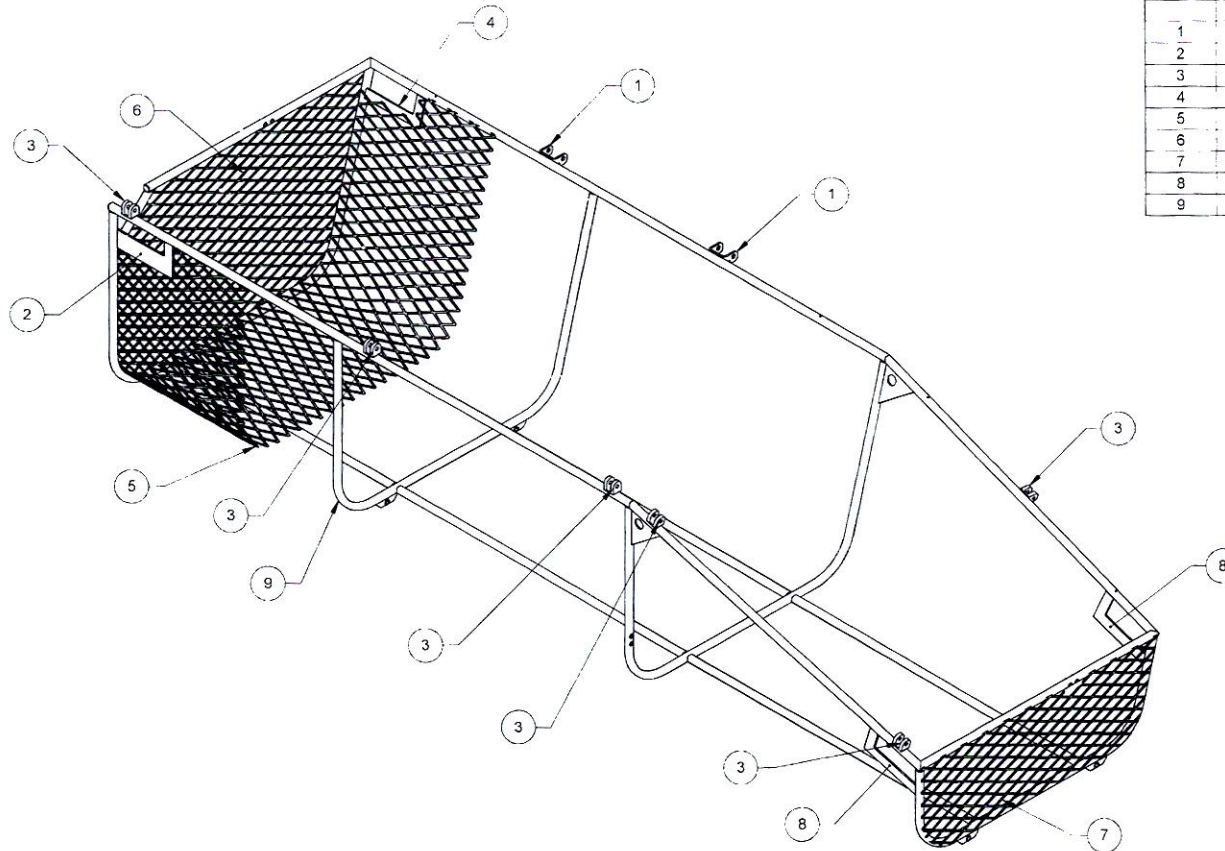
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date: _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

PRELIMINARY ISSUE



ITEM	QTY. -041	P/N	DESCRIPTION
	X	D5331-041	BASKET BASE ASSY, LH
1	2	D2581	MOUNTING BRACKET
2	1	D3913-15	WIDE HANDLE PLATE
3	6	D4016-1	HINGE HALF, BASE
4	1	D4021-1	HANDLE PLATE
5	1	D5328-1	MESH, BASE
6	1	D5328-3	MESH END, AFT
7	1	D5328-5	MESH END, FWD
8	2	D5330-1	HANDLE PLATE
9	1	D5331-101	TUBULAR BASKET BASE ASSY, LH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 137982 M.C.S.
15-10-19

D5331-041 BASKET BASE ASSY, LH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 25.46 lbs
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

PRELIMINARY ISSUE

REV.	NEW ISSUE	DESCRIPTION	RF	15.08.10
DESIGN	RF		BY	DATE
DRAWN	RF			
CHECKED	AK			
MFG. APPR.	DD			
APPROVED				
DE APPR.				
DATE	15.08.10			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D5331

TITLE

BASKET BASE ASSY

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REV. A4

SHEET 1 OF 10

SCALE

NTS

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

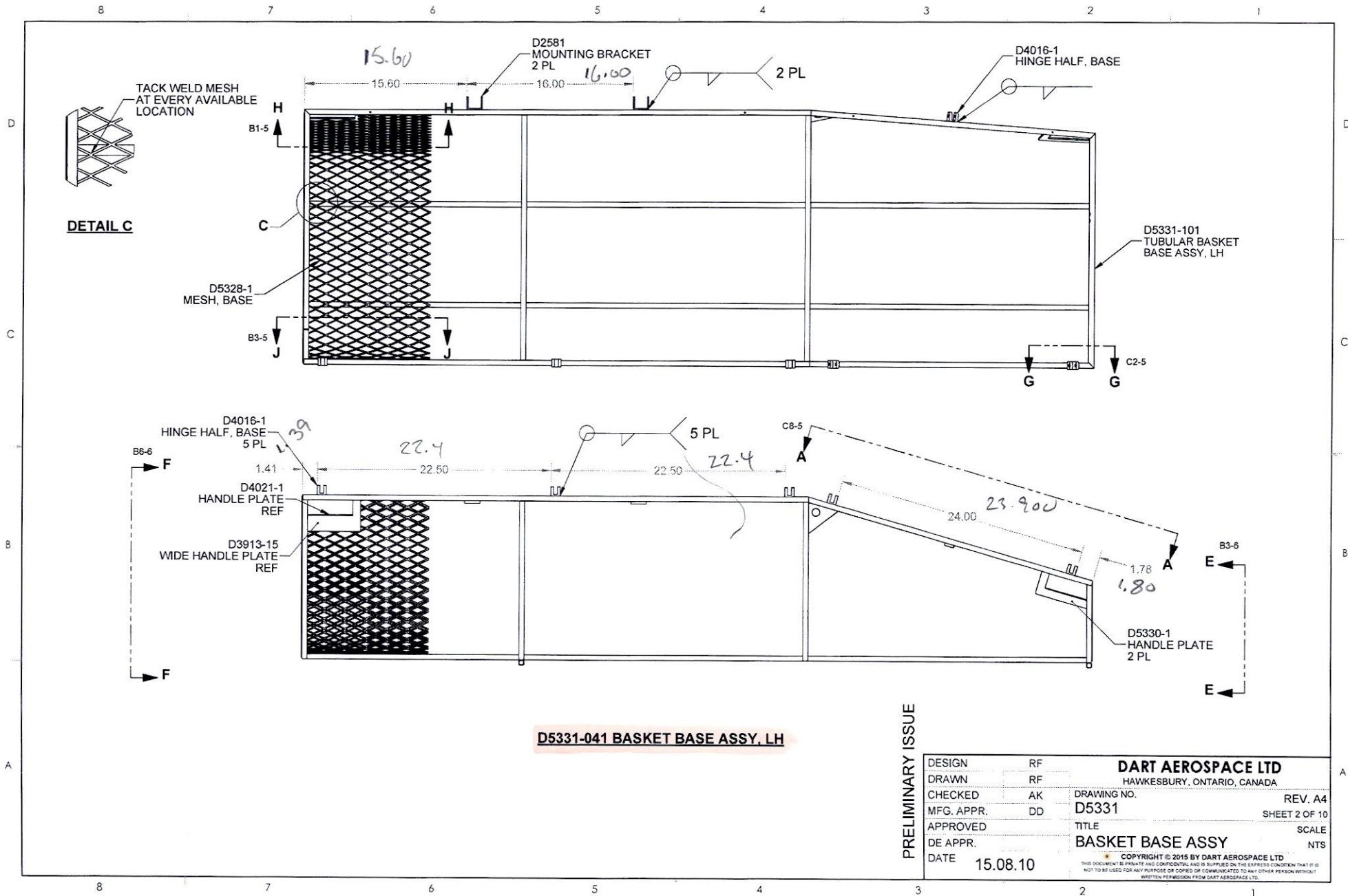
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified ☐	☐	Past Due	☐				

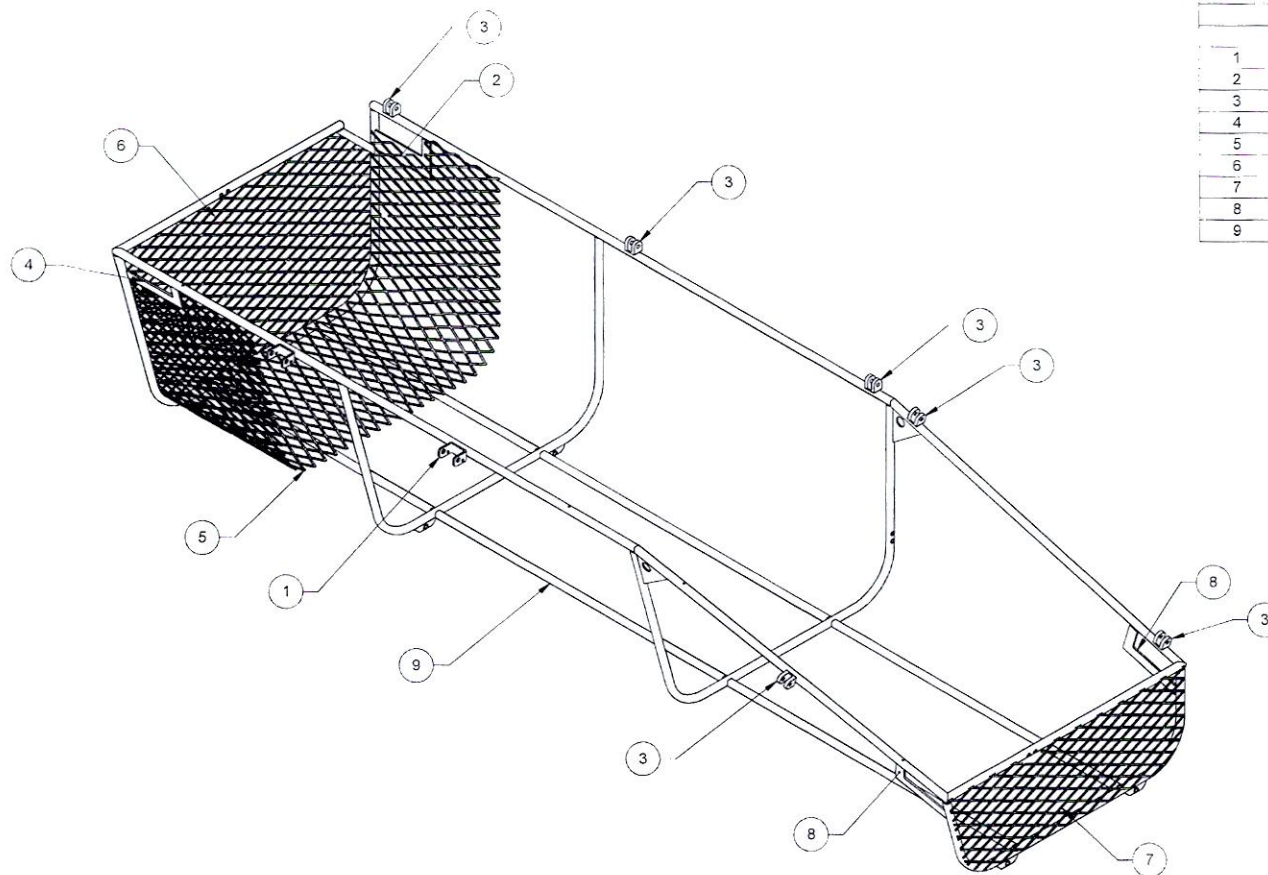
PRELIMINARY ISSUE



PRELIMINARY ISSUE

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. A4
MFG. APPR.	DD	D5331	SHEET 2 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
DATE	15.08.10	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY. -042	P/N	DESCRIPTION
	X	D5331-042	BASKET BASE ASSY, RH
1	2	D2581	MOUNTING BRACKET
2	1	D3913-15	WIDE HANDLE PLATE
3	6	D4016-1	HINGE HALF, BASE
4	1	D4021-1	HANDLE PLATE
5	1	D5328-1	MESH, BASE
6	1	D5328-3	MESH END, AFT
7	1	D5328-5	MESH END, FWD
8	2	D5330-1	HANDLE PLATE
9	1	D5331-102	TUBULAR BASKET BASE ASSY, RH



D5331-042 BASKET BASE ASSY, RH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 25.46 lbs
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

PRELIMINARY ISSUE

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. A4
MFG. APPR.	DD	D5331	SHEET 3 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
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DQA: _____ Date: _____



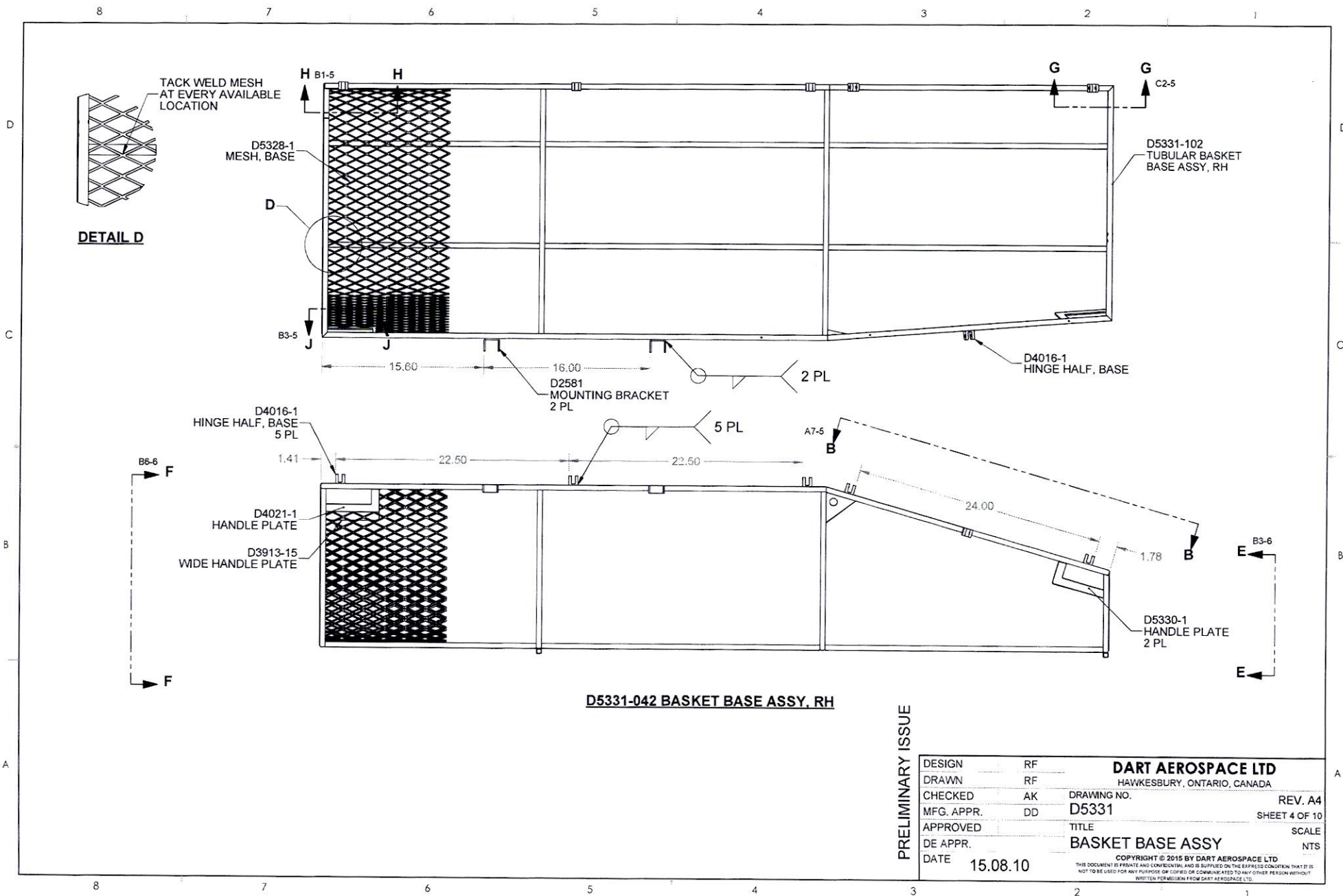
WORK ORDER NON-CONFORMANCE / UPDATE

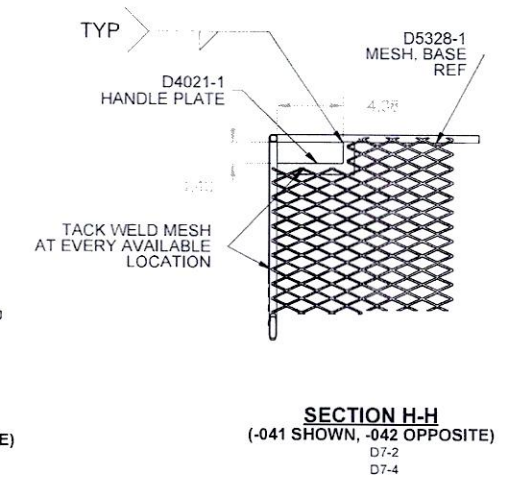
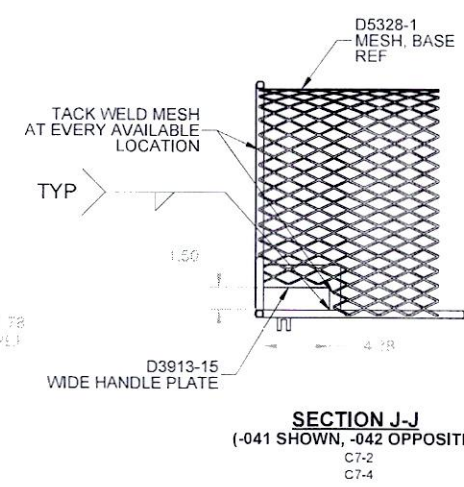
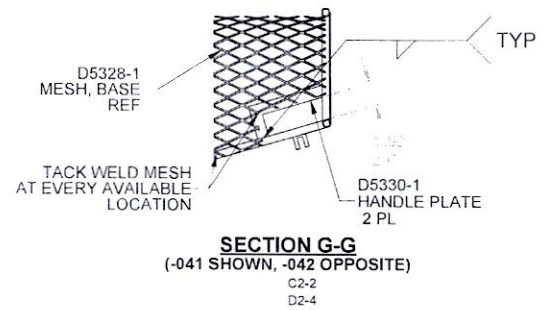
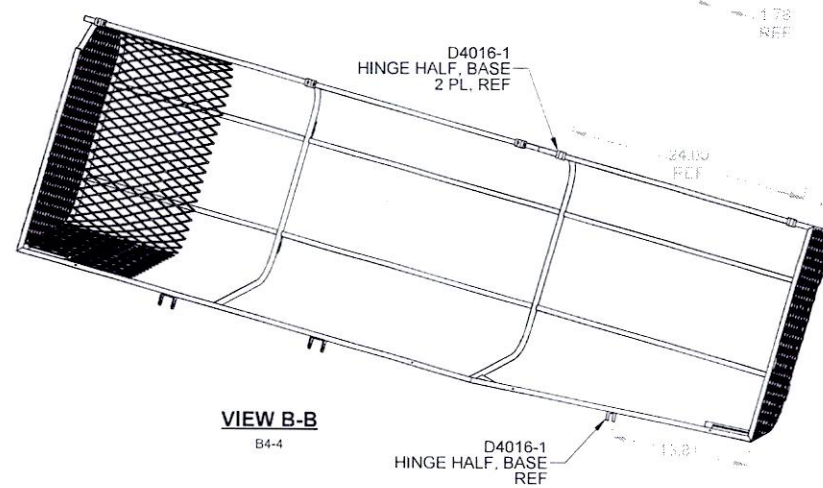
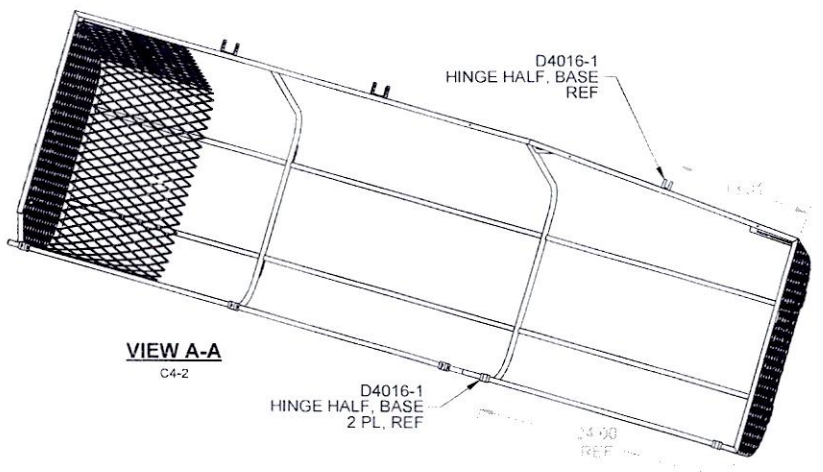
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

PRELIMINARY ISSUE





PRELIMINARY ISSUE

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. A4
MFG. APPR.	DD	D5331	SHEET 5 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
DATE	15.08.10	COPYRIGHT © 2015 BY DART AEROSPACE LTD THE INFORMATION IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



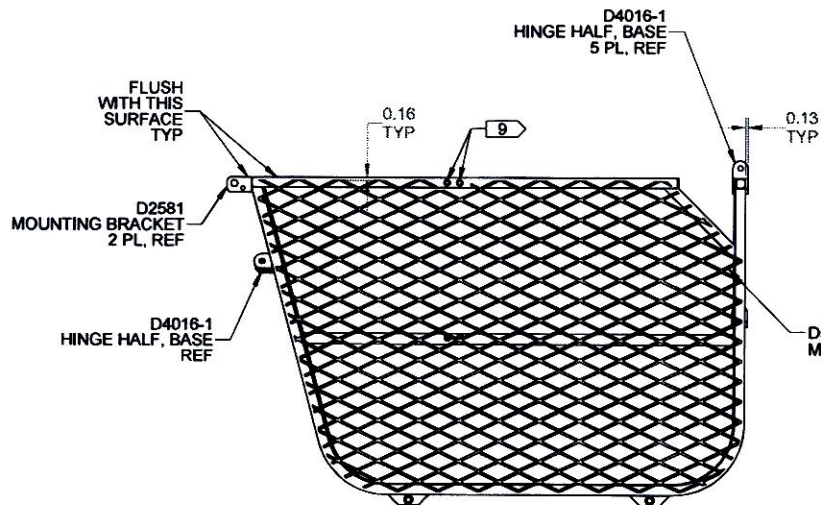
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

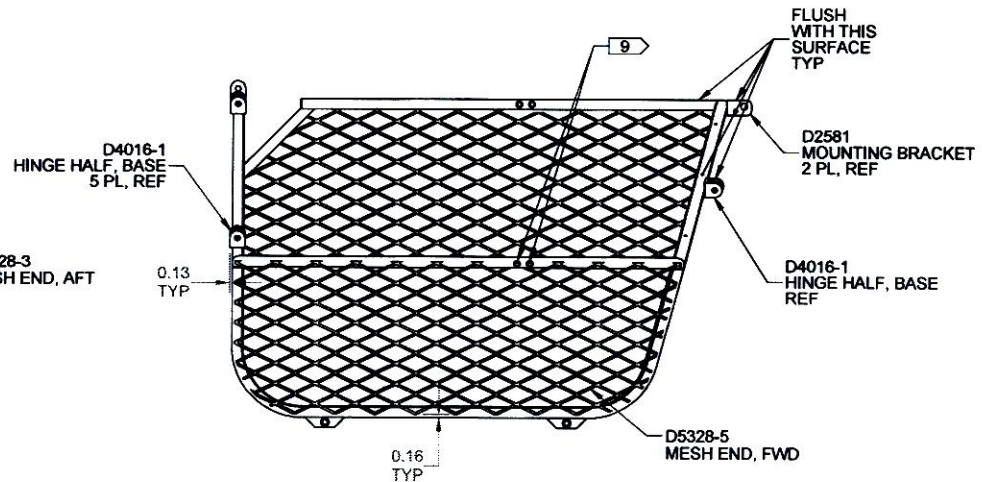
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

PRELIMINARY ISSUE



VIEW F-F
(-041 SHOWN, -042 OPPOSITE)
B8-2
B8-4

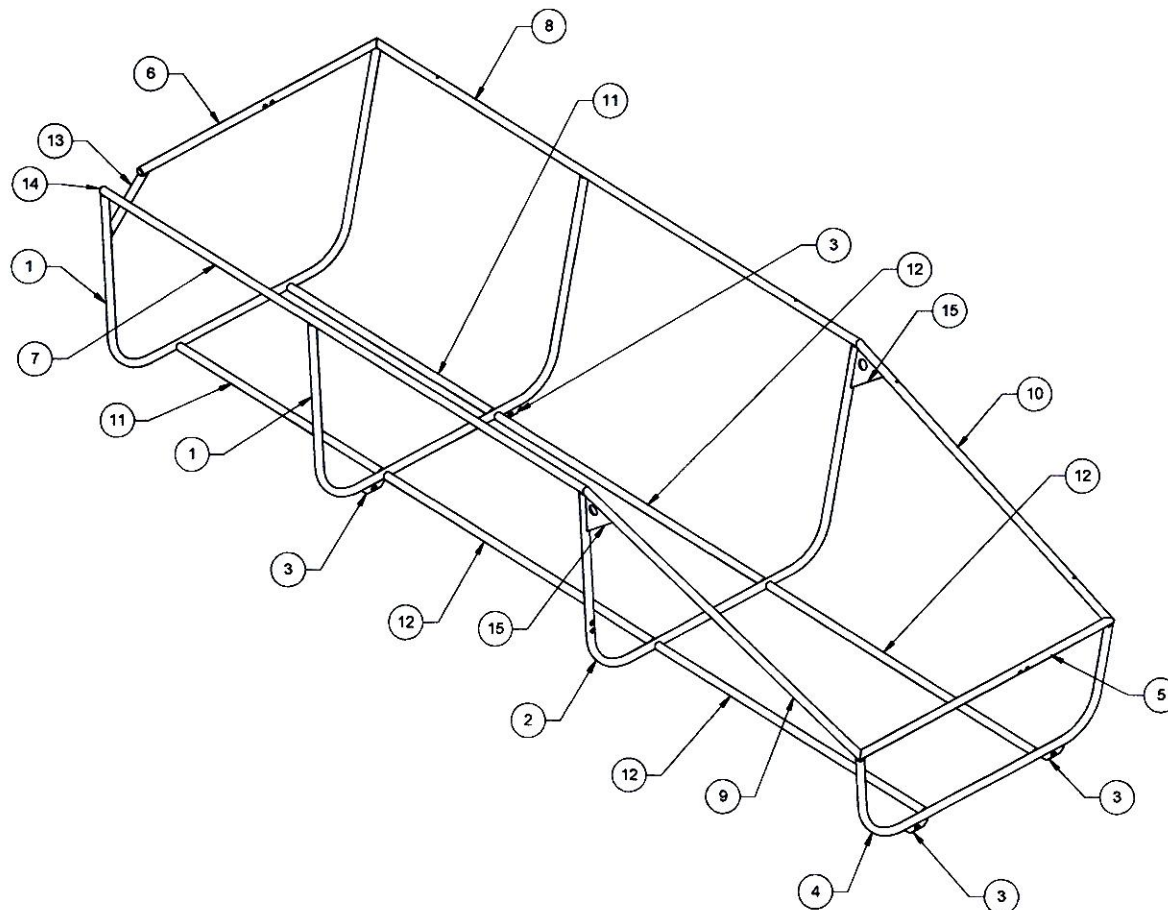


VIEW E-E
(-041 SHOWN, -042 OPPOSITE)
B1-2
B1-4

PRELIMINARY ISSUE

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. A4
MFG. APPR.	DD	D5331	SHEET 6 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
DATE	15.08.10	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

PRELIMINARY ISSUE



ITEM	QTY -101	P/N	DESCRIPTION
	X	D5331-101	TUBULAR BASKET BASE ASSY, LH
1	2	D3916-5	LIGHT RIB
2	1	D5325-041	RIB ASSEMBLY
3	4	D5325-043	RIB ASSEMBLY
4	1	D5325-3	LIGHT RIB
5	1	D5326-041	RIB ASSEMBLY
6	1	D5326-043	RIB ASSEMBLY
7	1	D5327-1	RIB
8	1	D5327-3	RIB
9	1	D5327-5	RIB
10	1	D5327-7	RIB
11	2	D5327-9	RIB
12	4	D5327-11	RIB
13	1	D5327-13	RIB
14	1	D5327-15	CAP
15	2	D5329-1	GUSSET

D5331-101 TUBULAR BASKET BASE ASSY, LH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 11.99 lbs
- 8) WELD PER DART QSI 004

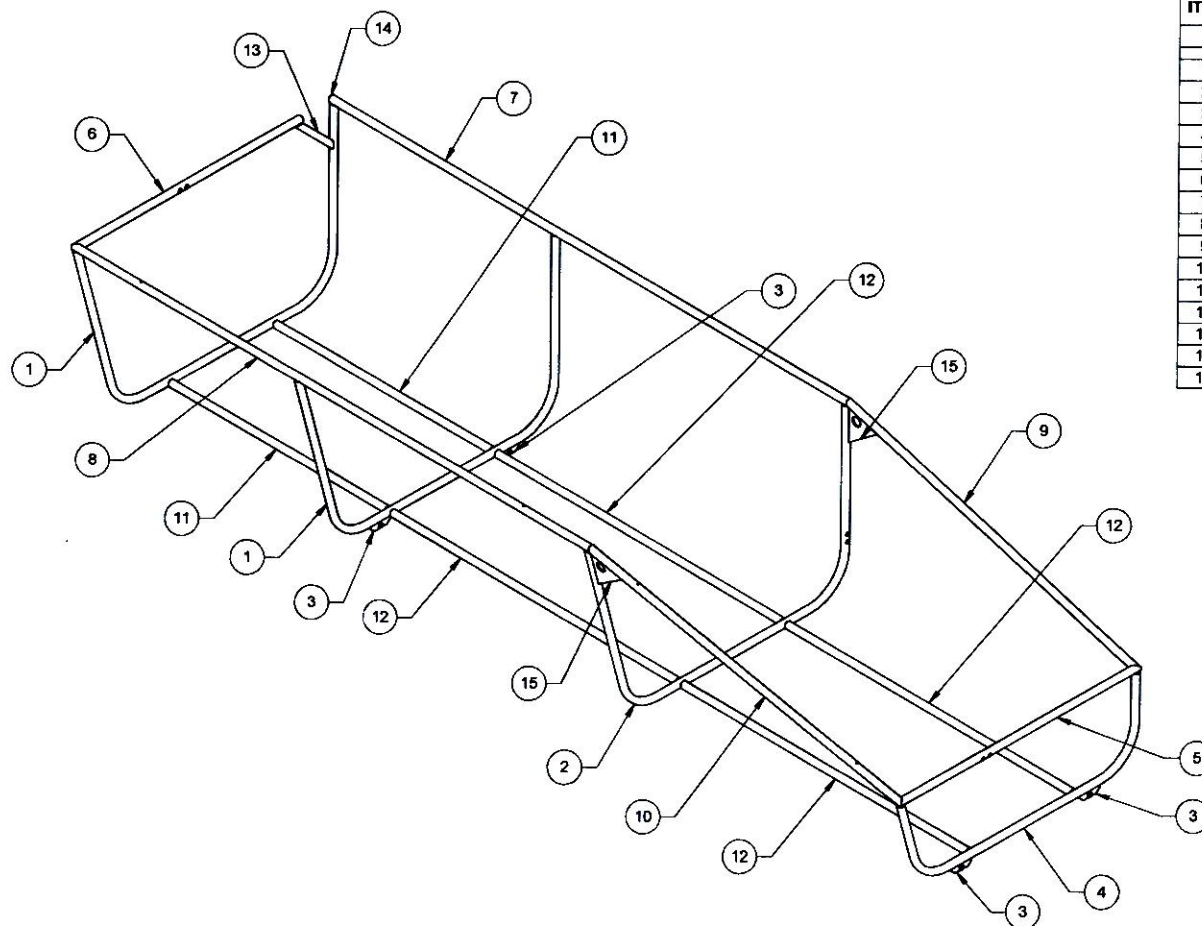
PRELIMINARY ISSUE

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. A4
MFG. APPR.	DD	D5331	SHEET 7 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
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D5331-101 TUBULAR BASKET BASE ASSY, LH

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. A4
MFG. APPR.	DD	D5331	SHEET 8 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
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PRELIMINARY ISSUE



ITEM	QTY	P/N	DESCRIPTION
	X	D5331-102	TUBULAR BASKET BASE ASSY, RH
1	2	D3916-5	LIGHT RIB
2	1	D5325-041	RIB ASSEMBLY
3	4	D5325-043	RIB ASSEMBLY
4	1	D5325-4	LIGHT RIB
5	1	D5326-041	RIB ASSEMBLY
6	1	D5326-043	RIB ASSEMBLY
7	1	D5327-1	RIB
8	1	D5327-4	RIB
9	1	D5327-6	RIB
10	1	D5327-8	RIB
11	2	D5327-9	RIB
12	4	D5327-11	RIB
13	1	D5327-13	RIB
14	1	D5327-15	CAP
15	2	D5329-1	GUSSET

D5331-102 TUBULAR BASKET BASE ASSY, RH

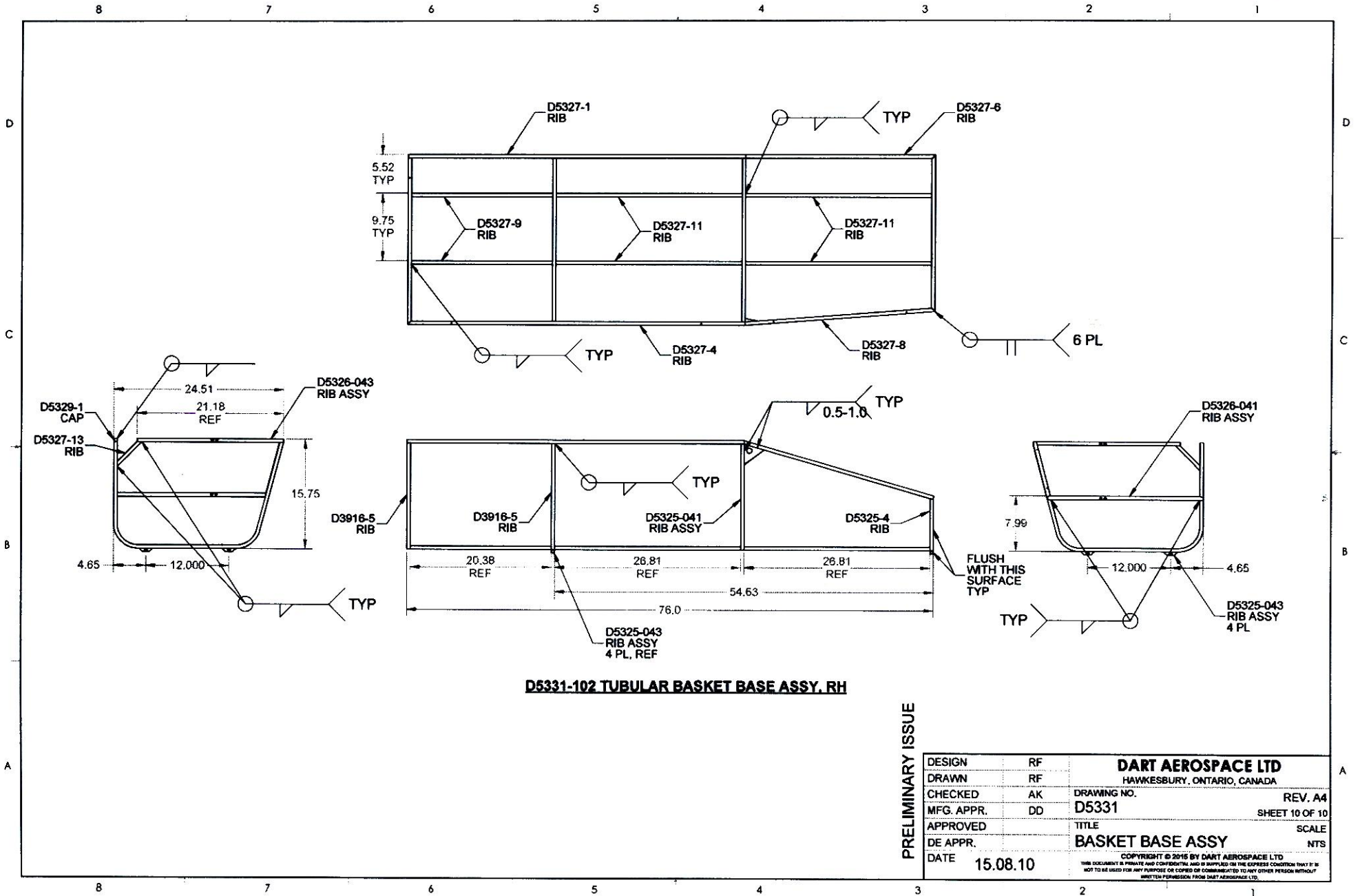
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 11.99 lbs
- 8) WELD PER DART QSI 004

PRELIMINARY ISSUE

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. A4
MFG. APPR.	DD	D5331	SHEET 9 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
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PRELIMINARY ISSUE



PRELIMINARY ISSUE

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. A4
MFG. APPR.	DD	D5331	SHEET 10 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
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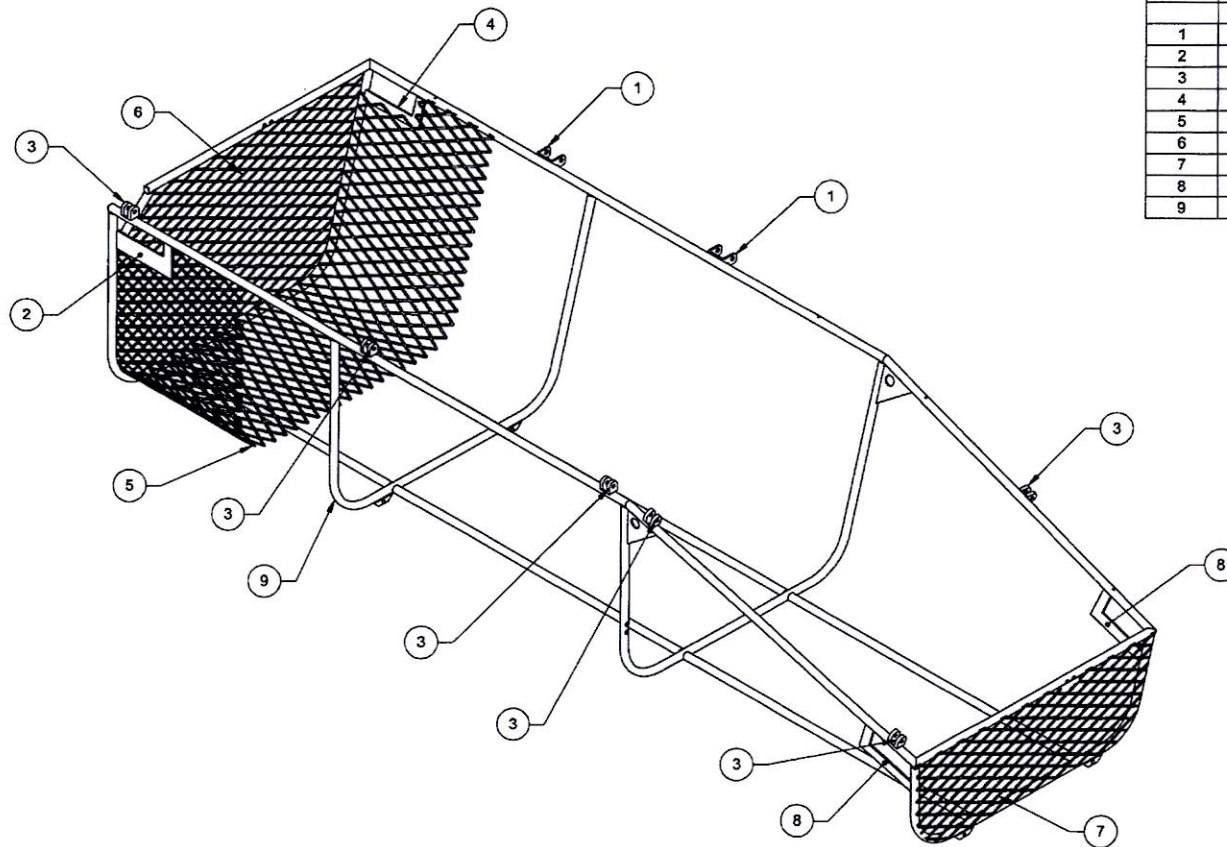
DART AEROSPACE LTD		Work Order: B137982
Description: Tubular BaseTBase Assy, LH		Part Number: D5331-101
Inspection Dwg: D5331	Rev: PA4	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.75"	$\pm .030$ "	9.625		✓		
24.51	$\pm .030$	24.40		✓		
21.18	$\pm .030$	21.125		✓		
15.75	$\pm .030$	15.625 15.625		✓		
12.000	$\pm .010$	12.00	✓			
20.38	$\pm .030$	20.30		✓		
26.81	$\pm .030$	26.75		✓		
26.81	$\pm .030$	26.75		✓		
76.00	$\pm .030$	75.900		✓		
12.000	$\pm .010$	12.00	✓			
7.99	$\pm .030$	7.875		✓		

Measured by: DAS	Audited by:	Preliminary Approval:
Date: 9-89 15/12/15	Date:	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	



ITEM	QTY. -041	P/N	DESCRIPTION
	X	D5331-041	BASKET BASE ASSY, LH
1	2	D2581	MOUNTING BRACKET
2	1	D3913-15	WIDE HANDLE PLATE
3	6	D4016-1	HINGE HALF, BASE
4	1	D4021-1	HANDLE PLATE
5	1	D5328-1	MESH, BASE
6	1	D5328-3	MESH END, AFT
7	1	D5328-5	MESH END, FWD
8	2	D5330-1	HANDLE PLATE
9	1	D5331-101	TUBULAR BASKET BASE ASSY, LH

D5331-041 BASKET BASE ASSY, LH
(MESH SHOWN LOCALLY FOR CLARITY)

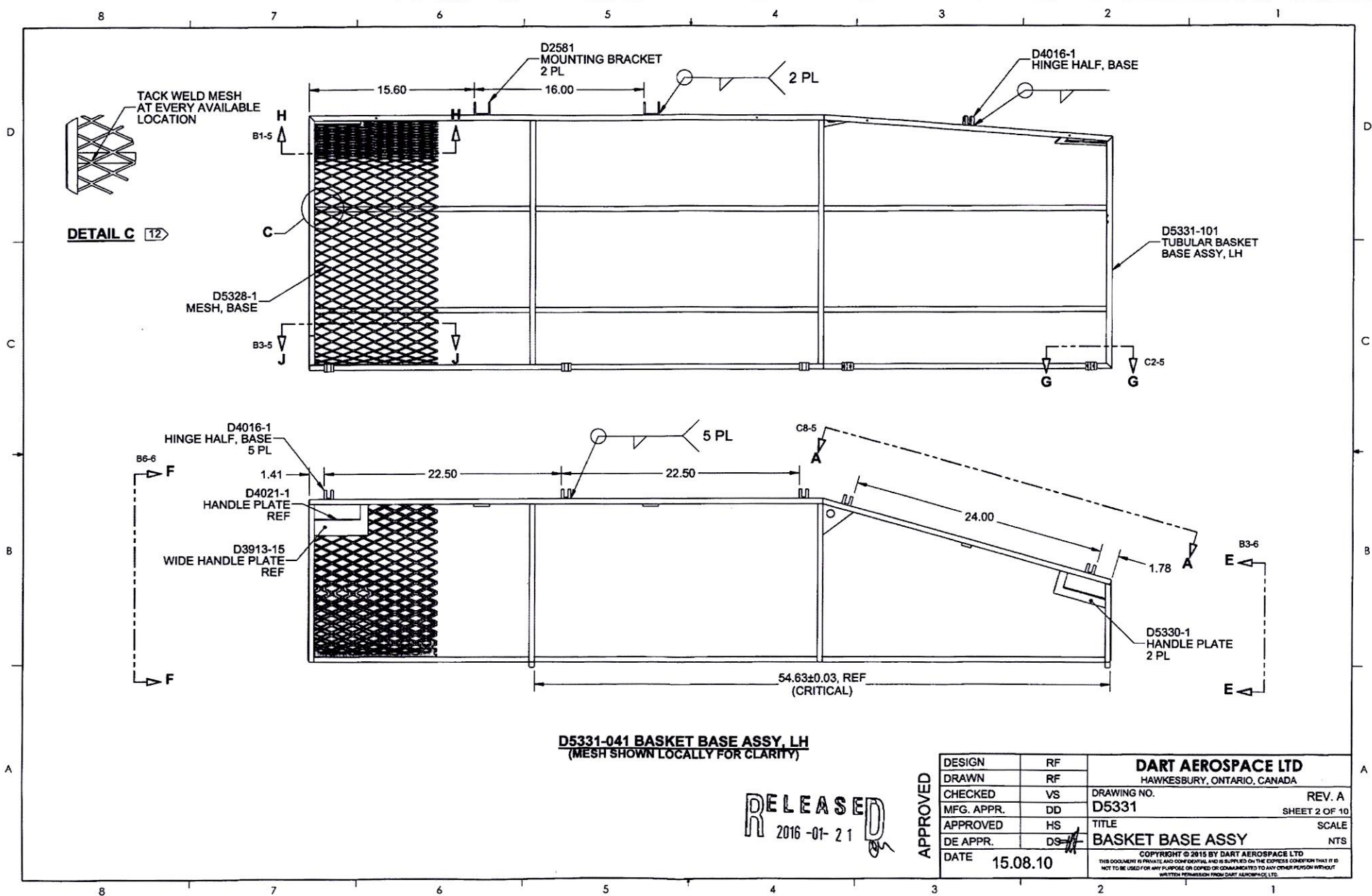
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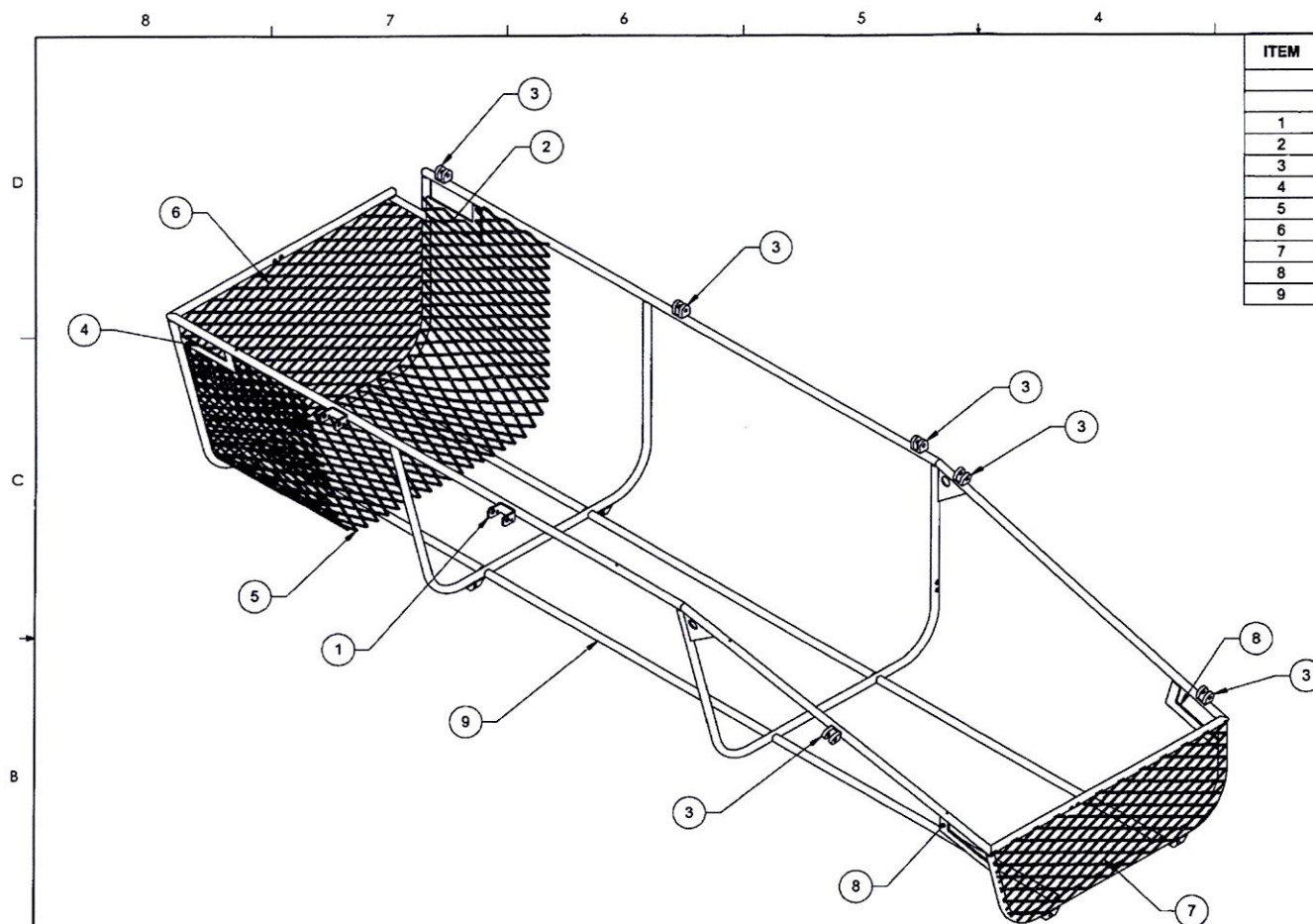
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 29.8 lbs
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) TOLERANCE FOR XX.XX DIMENSIONS IS ± 0.06 UNLESS OTHERWISE NOTED FOR D5331-041
- 11) WELD PER DART QSI 004
- 12) LOCAL TRIMMING MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE

RELEASED
2016-01-21

APPROVED

A		NEW ISSUE		RF	15.08.10
REV.	DESCRIPTION			BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	RF			SHEET 1 OF 10	
CHECKED	VS	DRAWING NO.		SCALE	
MFG. APPR.	DD	D5331		NTS	
APPROVED	HS	TITLE			
DE APPR.	DS	BASKET BASE ASSY			
DATE		15.08.10		COPYRIGHT © 2015 BY DART AEROSPACE LTD	
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ITEM	QTY. -042	P/N	DESCRIPTION
	X	D5331-042	BASKET BASE ASSY, RH
1	2	D2581	MOUNTING BRACKET
2	1	D3913-15	WIDE HANDLE PLATE
3	6	D4016-1	HINGE HALF, BASE
4	1	D4021-1	HANDLE PLATE
5	1	D5328-1	MESH, BASE
6	1	D5328-3	MESH END, AFT
7	1	D5328-5	MESH END, FWD
8	2	D5330-1	HANDLE PLATE
9	1	D5331-102	TUBULAR BASKET BASE ASSY, RH

D5331-042 BASKET BASE ASSY, RH
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 29.8 lbs
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) TOLERANCE FOR XX.XX DIMENSIONS IS ± 0.06 UNLESS OTHERWISE NOTED FOR D5331-042
- 11) WELD PER DART QSI 004
- 12) LOCAL TRIMMING MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE

RELEASED
2016-01-21

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5331	SHEET 3 OF 10
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET BASE ASSY	NTS
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TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

DETAIL D 12

D5328-1
MESH, BASE

D5331-102
TUBULAR BASKET
BASE ASSY, RH

D4016-1
HINGE HALF, BASE

D2581
MOUNTING BRACKET
2 PL

D4016-1
HINGE HALF, BASE
5 PL

D4021-1
HANDLE PLATE
D3913-15
WIDE HANDLE PLATE

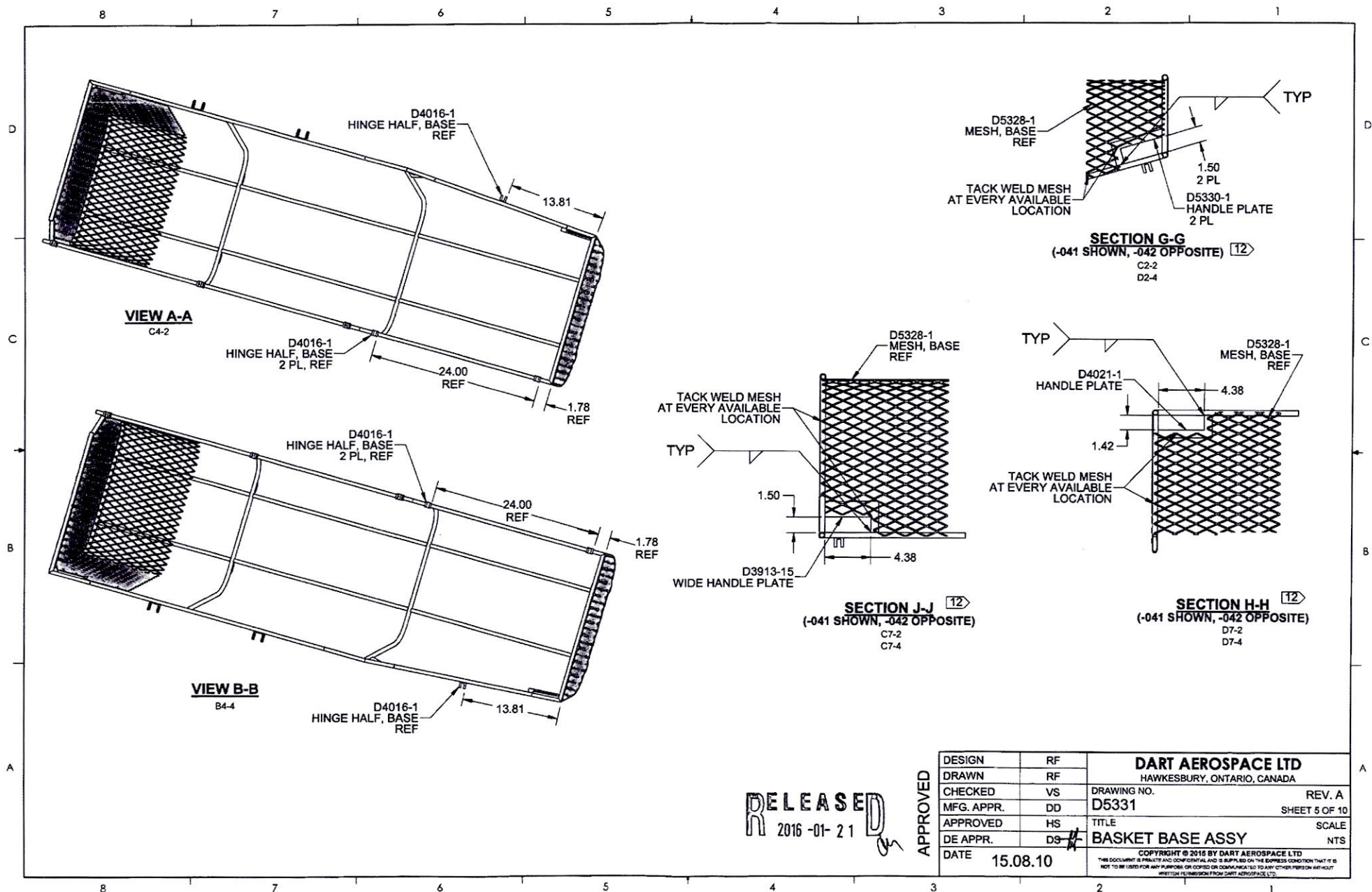
D5330-1
HANDLE PLATE
2 PL

D5331-042 BASKET BASE ASSY, RH
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2016-01-21

APPROVED

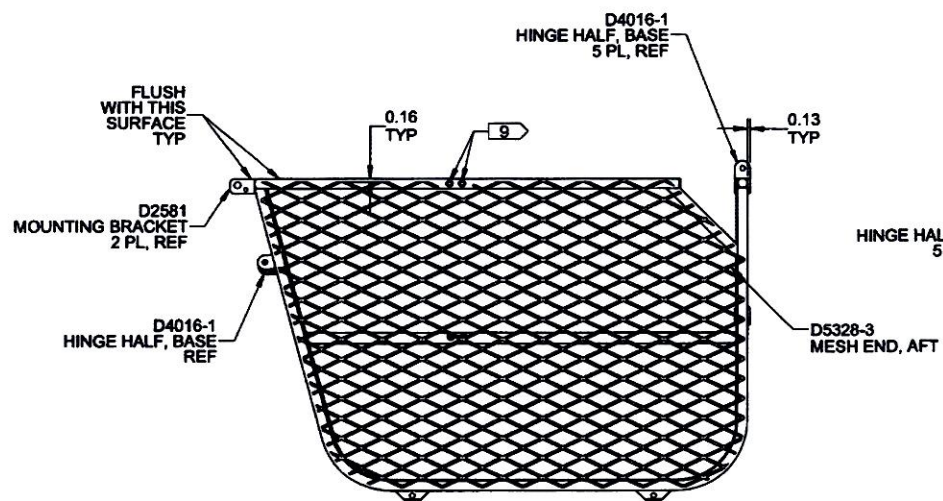
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5331	SHEET 4 OF 10
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET BASE ASSY	NTS
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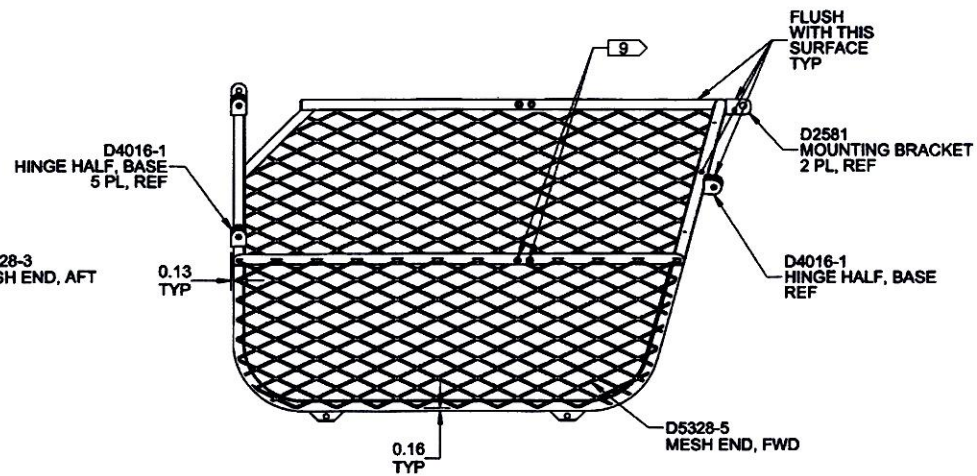
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2016-01-21

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5331	SHEET 5 OF 10
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET BASE ASSY	NTS
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VIEW F-F 12
 (-041 SHOWN, -042 OPPOSITE)
 B8-2
 B8-4

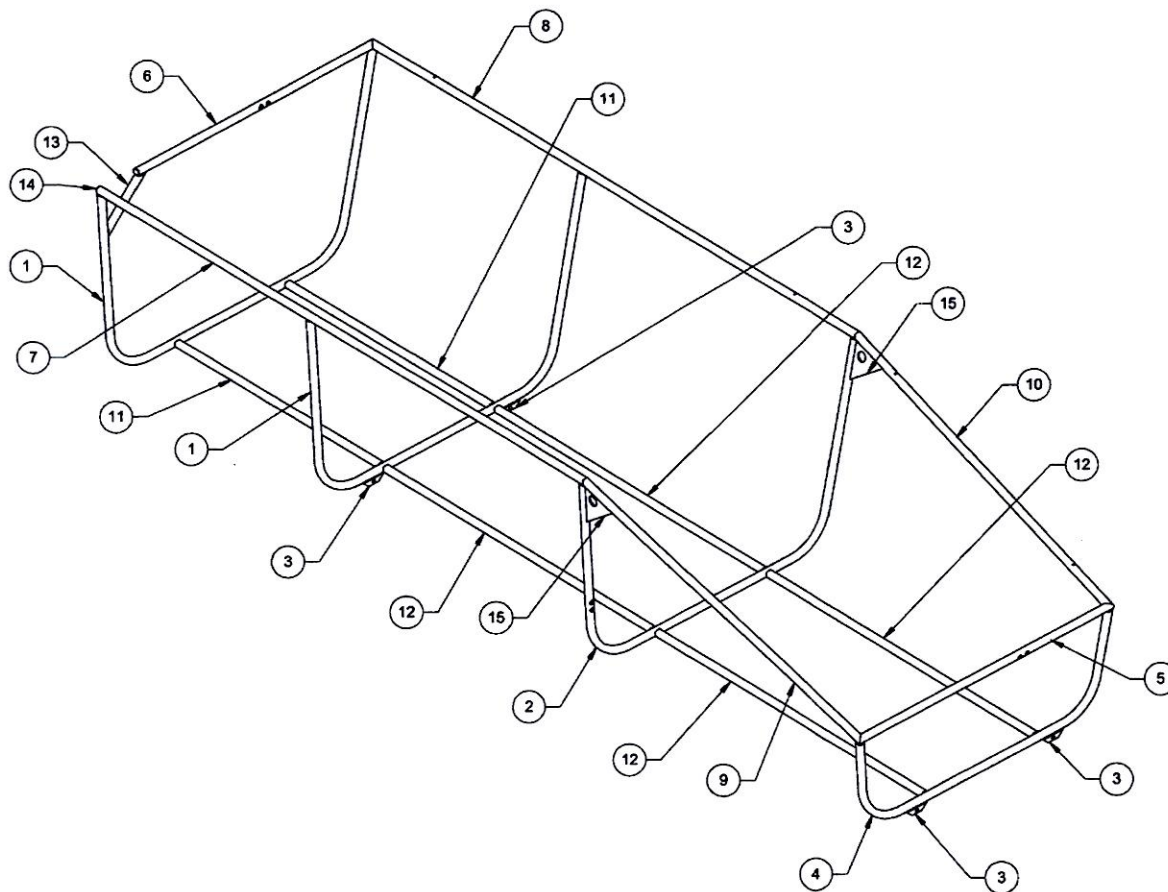


VIEW E-E 12
 (-041 SHOWN, -042 OPPOSITE)
 B1-2
 B1-4

RELEASED
 2016-01-21

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5331	SHEET 8 OF 10
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET BASE ASSY	NTS
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D5331-101 TUBULAR BASKET BASE ASSY, LH

ITEM	QTY -101	P/N	DESCRIPTION
	X	D5331-101	TUBULAR BASKET BASE ASSY, LH
1	2	D3916-5	LIGHT RIB
2	1	D5325-041	RIB ASSEMBLY
3	4	D5325-5	FOOT
4	1	D5325-3	LIGHT RIB
5	1	D5326-041	RIB ASSEMBLY
6	1	D5326-043	RIB ASSEMBLY
7	1	D5327-1	RIB
8	1	D5327-3	RIB
9	1	D5327-5	RIB
10	1	D5327-7	RIB
11	2	D5327-9	RIB
12	4	D5327-11	RIB
13	1	D5327-13	RIB
14	1	D5327-15	CAP
15	2	D5329-1	GUSSET

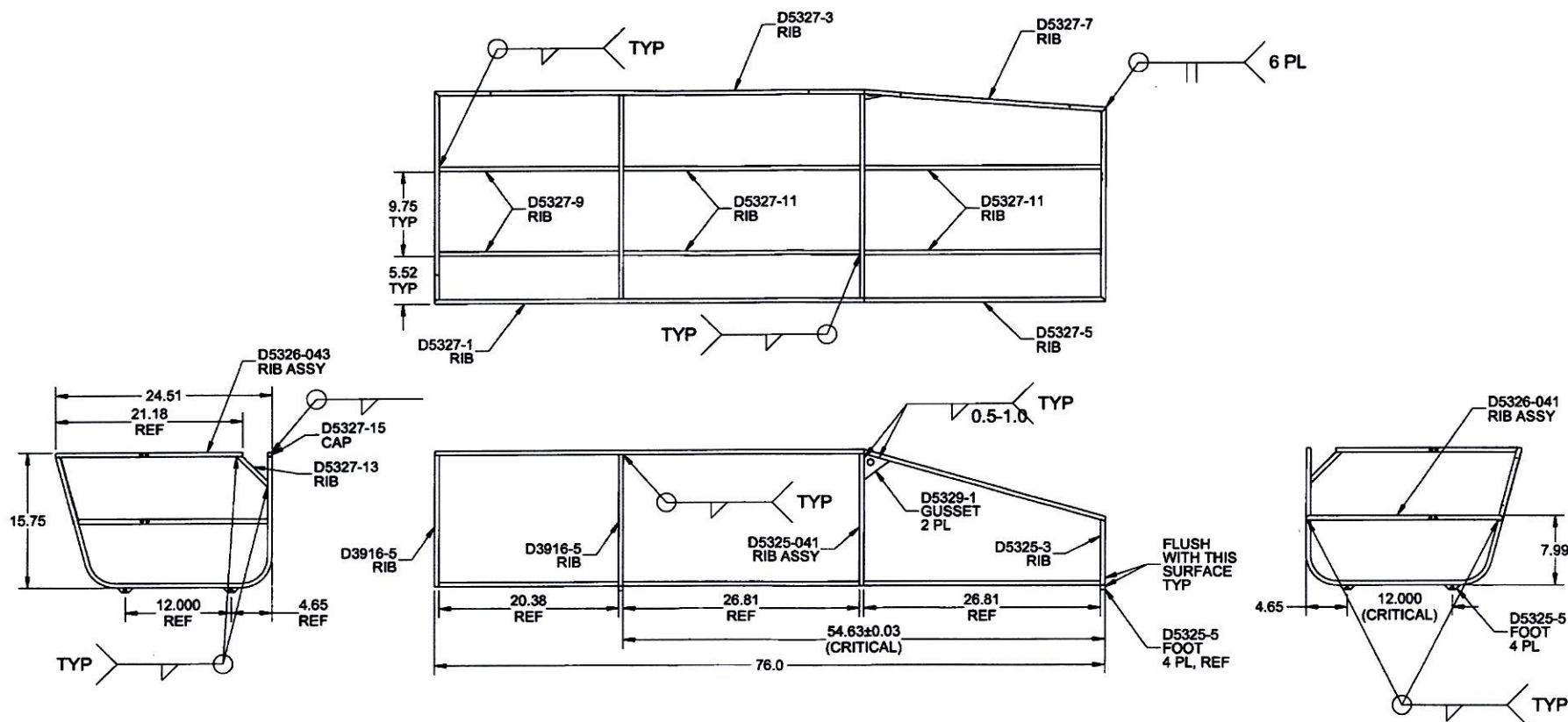
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 12.16 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS IS ± 0.100 UNLESS OTHERWISE NOTED FOR D5331-101
- 9) WELD PER DART QSI 004

RELEASE
2016-01-21

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D5331	REV. A
MFG. APPR.	DD	SHEET 7 OF 10	
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET BASE ASSY	NTS
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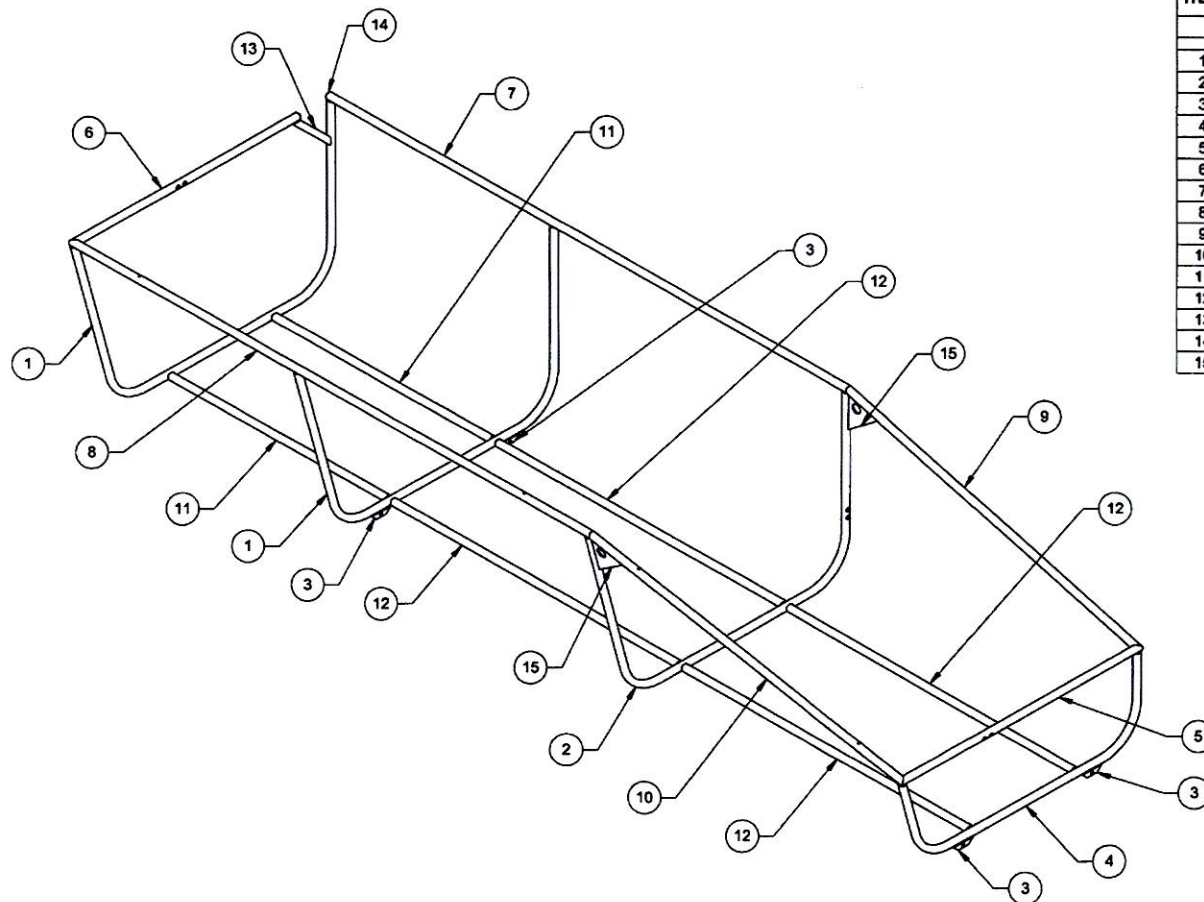


D5331-101 TUBULAR BASKET BASE ASSY, LH

RELEASED
2016-01-21

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5331	SHEET 8 OF 10
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET BASE ASSY	NTS
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D5331-102 TUBULAR BASKET BASE ASSY, RH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 12.16 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS IS ± 0.100 UNLESS OTHERWISE NOTED FOR D5331-102
- 9) WELD PER DART QSI 004

ITEM	QTY -102	P/N	DESCRIPTION
	X	D5331-102	TUBULAR BASKET BASE ASSY, RH
1	2	D3916-5	LIGHT RIB
2	1	D5325-041	RIB ASSEMBLY
3	4	D5325-5	FOOT
4	1	D5325-4	LIGHT RIB
5	1	D5326-041	RIB ASSEMBLY
6	1	D5326-043	RIB ASSEMBLY
7	1	D5327-1	RIB
8	1	D5327-4	RIB
9	1	D5327-6	RIB
10	1	D5327-8	RIB
11	2	D5327-9	RIB
12	4	D5327-11	RIB
13	1	D5327-13	RIB
14	1	D5327-15	CAP
15	2	D5329-1	GUSSET

RELEASED
2016-01-21

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5331	SHEET 9 OF 10
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET BASE ASSY	NTS
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